

Date: Wednesday, 11/07/2007 8:41:25 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 33333		Part Number	: D33156	
Estimate Number	: 10750		Drawing Number	: D3315 REV. B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 11/07/2007	S.O. No. :	Drawing Revision	: B	
Prsh Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 31/07/2007 Qty: 6 Um: Each	
Previous Run	: 33333				
Written By	: <u>L</u>				
Checked & Approved By	:				
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM				

Additional Product

Job-Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M1010S16GA	1010/1025/A21/6aA SHEET			SAD 07/07/24 "Scrap" ①
		Comment: Qty.: 1.9262 sf(s)/Unit Total : 11.5574 sf(s) 1010/1025/A21/6aA SHEET .060" THK BATCH: M104 948			SAD 07/07/24 ⑥
2.0	WATER JET	FLOW WATER JET			SAD 07/07/24 6
		Comment: FLOW WATER JET 1-Cut as per Dwg D3315 Dwg Rev: B Prog Rev: B			
		2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			SAD 07/07/24 6
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK			2007(07/24) X6
		Comment: SECOND CHECK			
5.0	BRAKE NC	NC BRAKE			SAD 07/12/10 6
		Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

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Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC6	DIMENSIONAL CHECK
		<i>S 01/10 x 6 cards</i>
	Comment: DIMENSIONAL CHECK	
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		<i>FC 08/01/10 ⑥</i>
	Comment: LARGE FABRICATION RESOURCE 1	
	Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: <i>B</i>	
	Qty Part Number Description Batch	
A/R	N/A	7560 Hardcoat Rod <i>m106390</i>
8.0	QC9	VISUAL WELDING INSPECTION
		<i>ID 08/01-10 ①</i>
	Comment: VISUAL WELDING INSPECTION	
9.0	POWDER COATING	POWDER COATING
		<i>M 106 442 6x 08/01/18</i>
	Comment: POWDER COATING	
	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>BR 08-01-18 6x 08/01/18</i>
	Comment: INSPECT POWDER COAT	
11.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>AS 08/01/18 (X6)</i>
	Comment: PACKAGING RESOURCE #1	
	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-6, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location: <i>ST 495</i>	
12.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>AS 08.01.21</i>
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



AS 08-01-21

Date: Monday, 7/9/2007 11:42:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 33333		Part Number	: D33156		
Estimate Number	: 10750		Drawing Number	: D3315 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/9/2007		Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 7/30/2007 Qty: 6 Um: Each		
Previous Run	: 26188					
Written By	:					
Checked & Approved By	:					
Comment	:		Est: 05.05.12 New issue KJ/JLM			
			Est Rev.B As per Rev B 06-03-24 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3315 Possible Supplier: Industrial Laser Material release note is required
2.0	D33156F	Wearplate Flat Pattern Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) WEARPLATE
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK Inspect dimensions as per inspection template D3315-6T2
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3315-6 PAR #: N/A Fault Category: Proc - Sm. Fab. NCR: Yes No DQA: A Date: 08.01.21
(WS) QA: N/C Closed: X Date: 08.01.22

NCR: <u>33333</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/24	2.0	One part scrap Dxf error and offset had to change hole were to big	<u>J</u> <u>05/02/24</u>	<u>Scrap & destroy replace</u> <u>Fix Dxf error</u>	<u>07/02/24</u> <u>SAO</u> <u>07/02/24</u>	<u>J</u> <u>07/02/24</u>	<u>J</u> <u>07/02/24</u>	<u>J</u> <u>07/02/24</u>

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:42:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33333

Part Number: D33156

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: _____

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	_____

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:42:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33333

Part Number: D33156

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

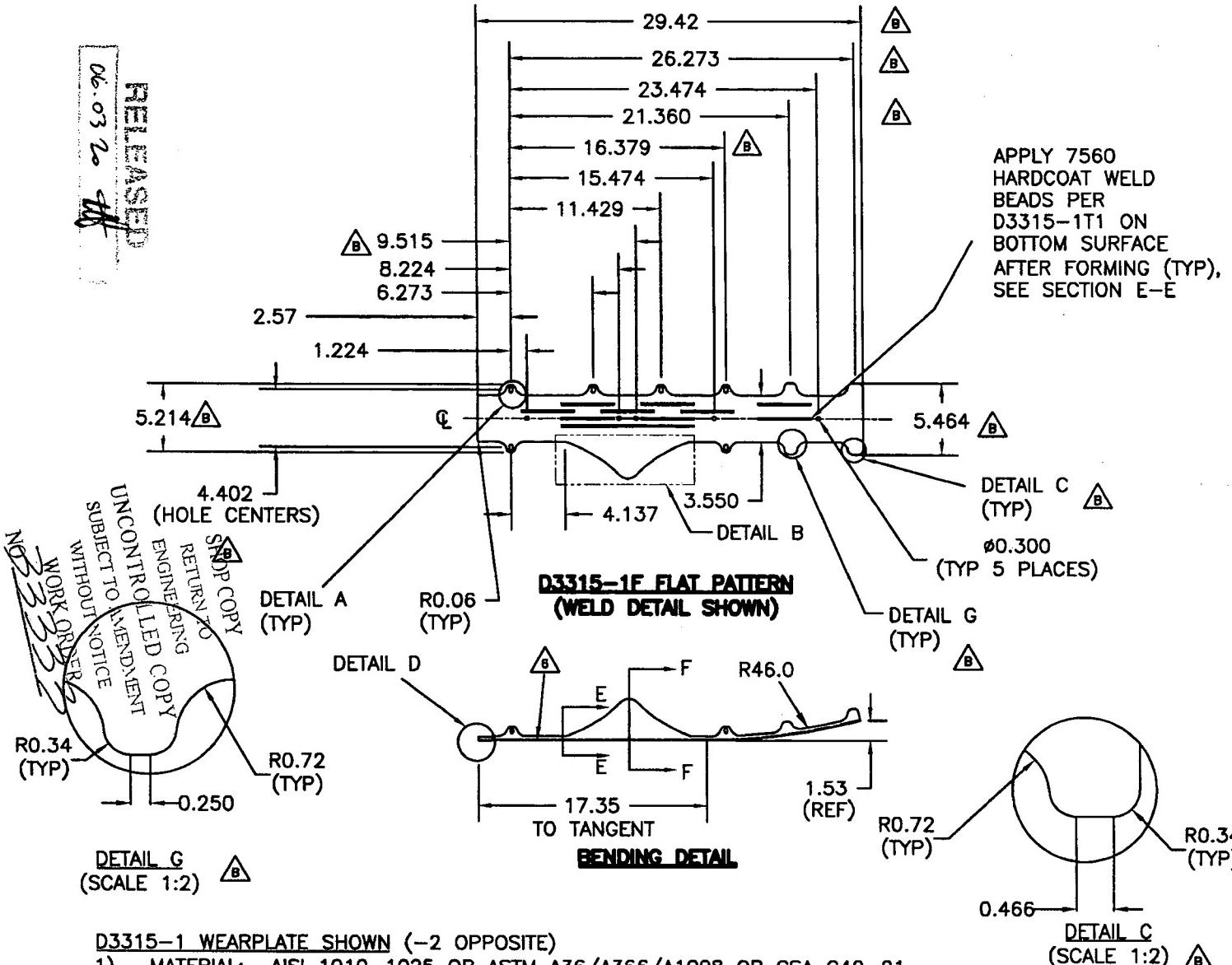
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BY	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3315
DATE 06.01.31	TITLE WEARPLATE	REV. B
A B	04.09.10 06.01.31	SHEET 1 OF 4 1:12 SCALE

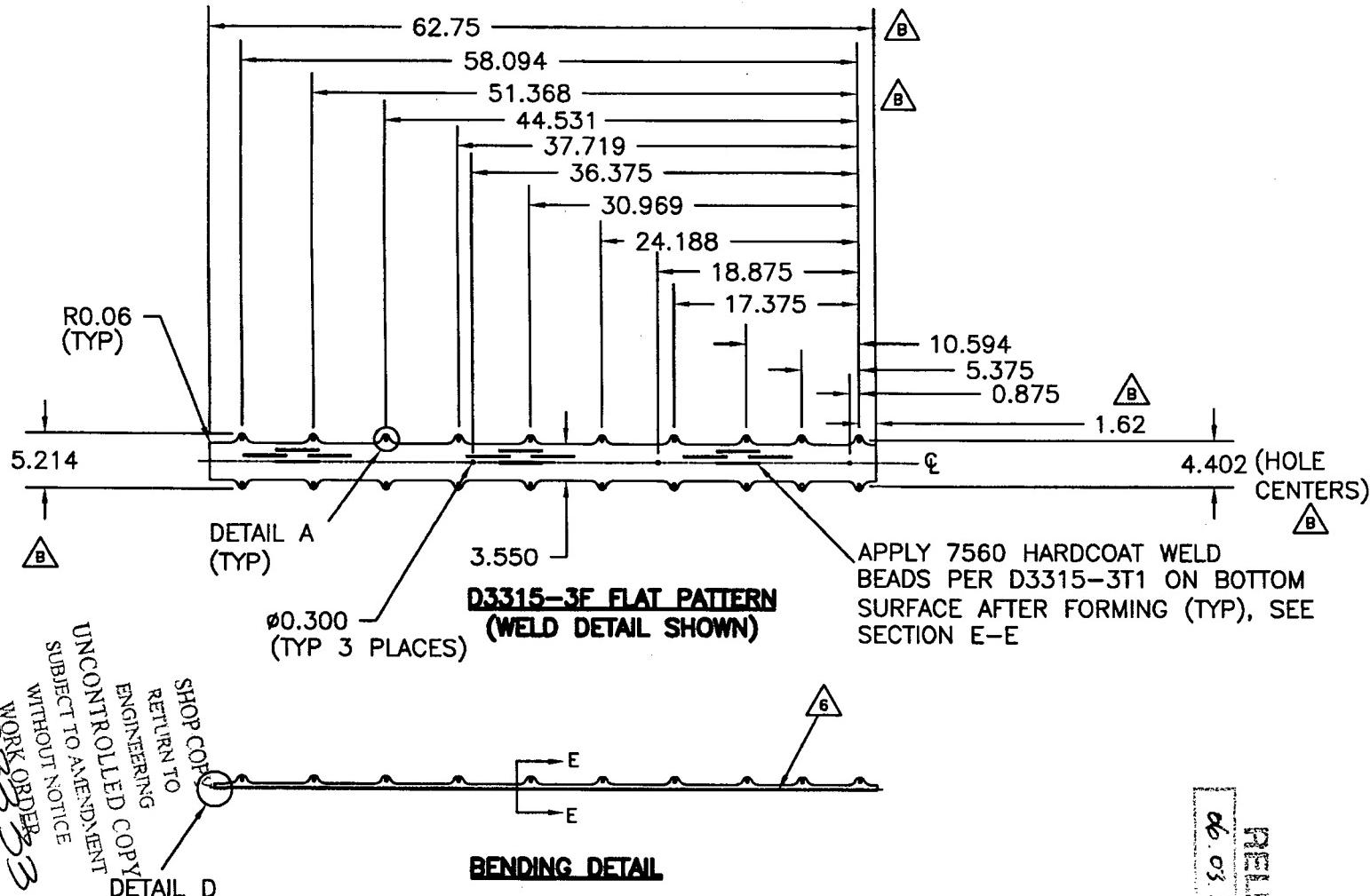
RELEASED
06.03.20 *[Signature]*





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D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

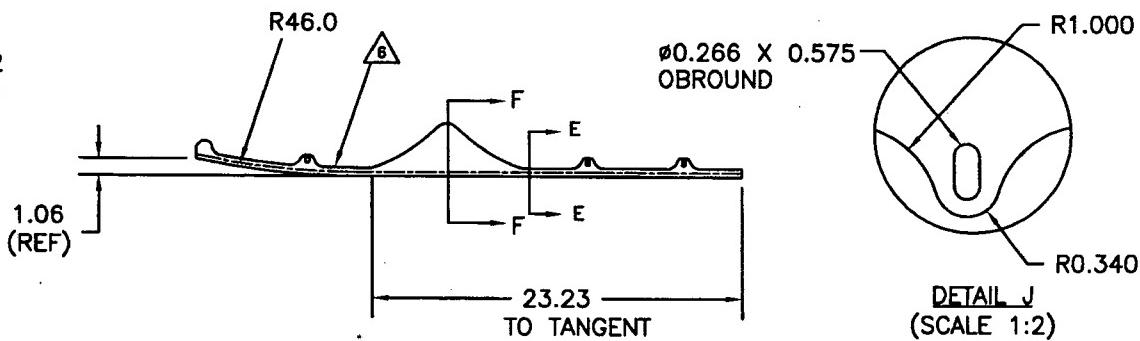
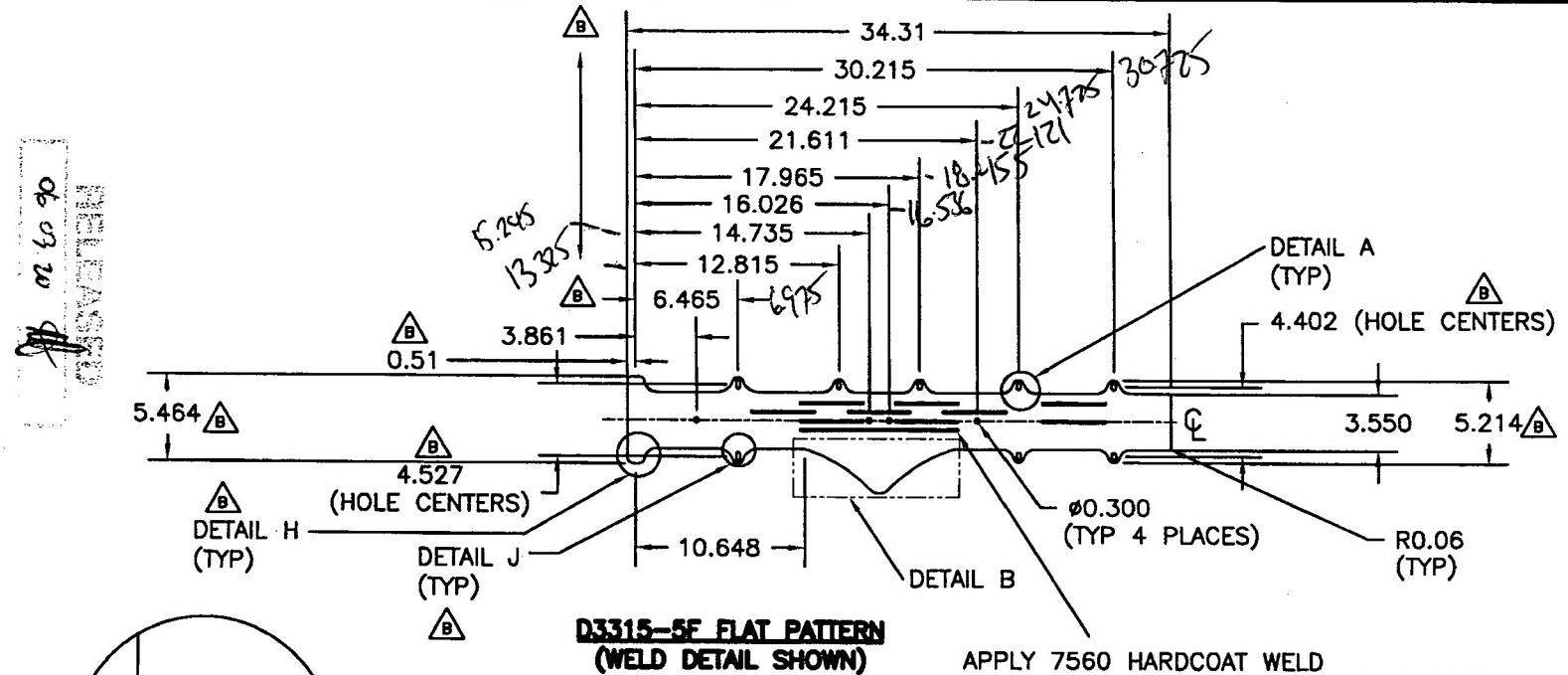
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

ab. 03.20

DESIGN	<i>PJ</i>	DRAWN BY <i>PJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3315	REV. B SHEET 2 OF 4
DATE	06.01.31	TITLE WEARPLATE	SCALE 1:16	

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 06.01.31	DRAWING NO. D3315	REV. B SHEET 3 OF 4



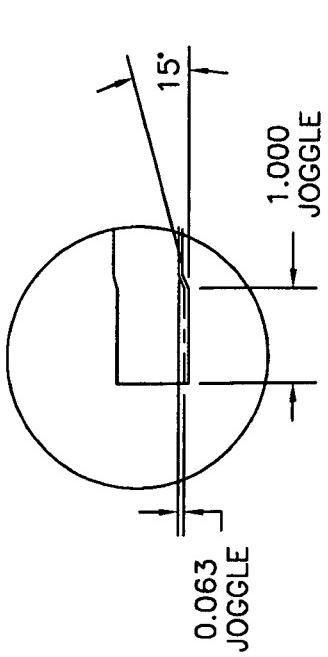
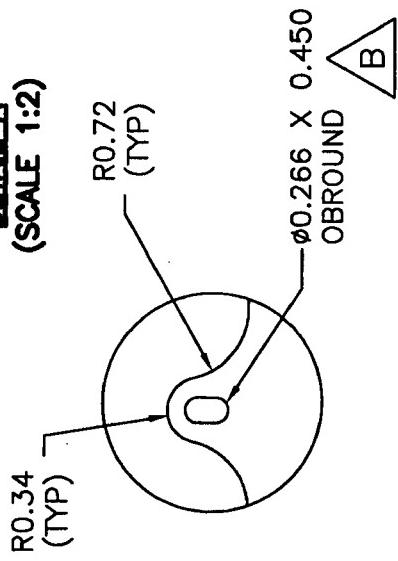
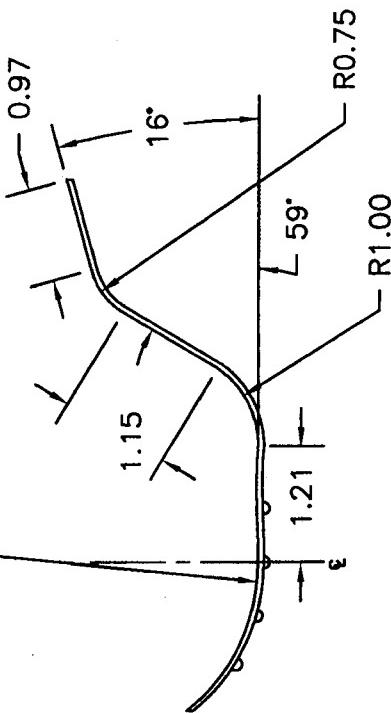
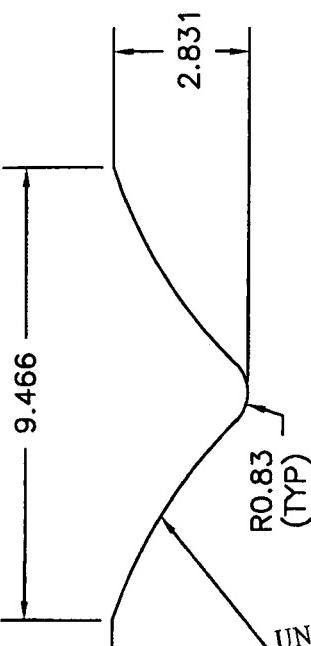
BENDING DETAIL

D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSION ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)**DETAIL D**
(SCALE 1:2)R2.00^{+0.030}_{-0.000}**SECTION F-F**
(SCALE 1:2)**DETAIL B**
(SCALE 1:4)R2.00^{+0.030}_{-0.000}

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
(TYP)
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33333

SECTION E-E
(SCALE 1:2)

(-1,-2,-5,-6 ONLY)
7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH

0.56
(TYP)

RELEASED

06.03.20

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DART AEROSPACE LTD	Work Order:	33333
Description: WEARPLATE	Part Number:	D33156
Inspection Dwg: D3315	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Suy	Audited by:	En	Prototype Approval:	✓
Date:	07/07/24	Date:	07/07/24	Date:	07/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

